



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4653-3
Job Sheet 165692-A



Part No: D4653-3

Job Qty: 35 ea

Part Name: Collar



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw	35 pcs		10/24/17	0.00	1.35	Bandsaw1		<i>S.S.</i>
105	Doosan	35 pcs		10/30/17	0.04	36.46	Doosan		<i>S.S.</i>
120	QC	35 pcs		10/30/17	0.00	0.00	QC8 Machining-3		<i>S.S. 18-01-11</i>
121	HandFinish	35 pcs		10/31/17	0.00	1.79	HandFinish1		<i>2018/01/16 JSL</i>
123	QC	35 pcs		10/31/17	0.00	0.00	QC7-4		<i>38</i>
130	Packaging	35 pcs		10/31/17	0.00	0.00	Packaging3-2		<i>9-89</i>
140	QC21-SA	35 Ea		10/31/17	0.00	0.00	QC21		<i>21 JAN 17 2018</i>

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Collar	60.000Degrees ± 0.500	60.500 59.500		Angle, Reference
2	Collar	0.865Inches ± 0.010	0.875 0.855		Diameter
3	Collar	0.812Inches $+ 0.001$ $- 0.000$	0.813 0.812		Diameter
4	Collar	0.060Inches ± 0.030	0.090 0.030		Radius
5	Collar	0.166Inches ± 0.010	0.176 0.156		
6	Collar	0.832Inches $+ 0.005$ $- 0.000$	0.837 0.832		
7	Collar	3.000Inches ± 0.030	3.030 2.970		Diameter
8	Collar	0.950Inches ± 0.010	0.960 0.940		
9	Collar	2.500Inches ± 0.030	2.530 2.470		
10	Collar	2.050Inches ± 0.030	2.080 2.020		
11	Collar	0.060Inches ± 0.030	0.090		Radius

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			0.030	
12	Collar	0.300Inches $\pm$ 0.030	0.330 0.270	
13	Collar	0.130Inches $\pm$ 0.030	0.160 0.100	Radius
14	Collar	1.800Inches $\pm$ 0.010	1.810 1.790	Diameter
15	Collar	2.000Inches $\pm$ 0.030	2.030 1.970	Diameter
16	Collar	2.150Inches $\pm$ 0.030	2.180 2.120	
17	Collar	0.030Inches $\pm$ 0.030	0.060 0.000	
18	Collar	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle

Plex 12/14/17 2:55 PM dart.lacelle.linda

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AEROSPACE
S022283

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Collar

PART NO: D4653-3
Revision:
Operation: QC
Change No:

Mfg Date: 12/14/17
Job No: 165692-A

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

